Work Order ID Tuesday, March 29, 2011	6 <b>7639</b> 8:23:00 AM							Page
Item ID: D3542-1 Revision ID:			Accept			s s	etup Start	
Item Name: Bracket Start Date: 3/28/2011 Required Date: 4/1/2011 Reference:	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item H Customer:	<b>):</b>		Stop	
Approvals: Process QC:	Plan:	Date://03-29	Tooling:  SPC (Y/N):	Da		R	Stop	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
	Revision Nbr Rev A	436	0.00		· · · · · · · · · · · · · · · · · · ·		,	
Bandsaw Jeaspa Bandsaw	BAND SAW  Memo  Cut blank	l.0" long	0.00	Luloylos	· · · · · · · · · · · · · · · · · · ·	_ 4_	<b>_</b>	:
HAAS I HAAS CNC vertical machine #1	HAAS CNC VERTICAL <b>Memo</b> 1- Mill as pe per dwg D34	r Folio FA684 Rev: _ <b>AA</b>	0.00 0.00 & Dwg D3542 Rev: _A	11 04 06 02-Deburr		6	<u></u> \$	
120 	QC2- Inspect parts off m	achine FAI/FAIB	0.00 0.00 B.e	, 11/04/04		6	<u></u>	

Quality Control

#### **Dart Aerospace Ltd WORK ORDER CHANGES** W/O: **Approval Approval** STEP PROCEDURE CHANGE DATE By Date Qty Chief Eng / Prod Mgr QC Inspector Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval STEP** DATE Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Chie Eng Date Chief Eng

Page 2

Tuesday, March 29, 2011 8:23:00 AM

Item ID:

D3542-1

**Revision ID:** 

Bracket Item Name:

**Start Date:** 

3/28/2011

Start Qty: 6.00

Accept

Setup Start

Stop



Required Date: 4/1/2011

Req'd Qty: 6.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

QC:

Process Plan:

Date: Date: \_\_\_\_\_

Tooling: **SPC (Y/N):** 

Date:

Start Stop



Sequence ID/

Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

0.00

and 11/04/06

Tool ID

Date:

Tool # Plan Qty Code

Accept Reject Qty

Run

Reject Number

Insp. Stamp

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

6 BL 11-4-7.

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

\*\*\*\*\*\*ENSURE TO MASK INSIDE BORE\*\*\*\*\* START TIME:

6 BK 11.4-7.

## **Dart Aerospace Ltd WORK ORDER CHANGES** W/O: Approval Chief Eng / Prod Mgr Approval QC Inspector STEP PROCEDURE CHANGE DATE Ву Date Qty

Part No:	PAR #: Fat	ult Category:	NCR: Yes No DQA:	Date:
Resolution:	Dis	 sposition:	QA: N/C Closed:	Date:

WORK ORDER NON-CONFORMANCE (NCR)

		D	,	Corrective Action Section B		1 .	Annroval	
DATE STEP	STEP	Description of NC Section A	<b>tial</b> f Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
		A SAME AND		,				
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Page 3

Tuesday, March 29, 2011 8:23:00 AM

Item ID:

D3542-1

**Revision ID:** Item Name: Bracket

**Start Date:** 

3/28/2011

QC:

Start Qty: 6.00

Req'd Qty: 6.00



Accept

Setup Start

Stop



Required Date: 4/1/2011

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Start Run

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject

Reject Number

Insp. Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

# **Dart Aerospace Ltd**

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDU	RE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·					
Part No	):	PAR #: Fai	ult Category:	NCR: Yes	No DQ	<b>^</b> <b>A</b> :	Date:	

Disposition: \_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_

NCR:		V	VORK	OR	DER NON-CONFORMANCE (NCF	R)	0	
		Description of NC	Description of NO		Corrective Action Section B	Verification	Annuaval	Annecel
DATE STE	STEP	Section A		<b>tial</b> Eng	Action Description Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Resolution:

#### **Picklist Print**

Tuesday, March 29, 2011 8:23:07 AM

Work Order ID: 67639

Parent Item: D3542-1

Parent Item Name: Bracket

Start Date: 3/28/2011

Required Date: 4/1/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev: A New Issue

07-04-23

JLM

11

IPP Rev: B updated powder coat per NCR 07.05.16

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5		Purchased	No		100	f	17.5000	0.3333333	າ			

6061-T6 Bar 3.00 x 1.50

<u>Location</u>	Loc Qty	Loc Code
MAT010	17.5	
→109058	7	1
114468	10.5	

2 onluloylos

**Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES** Approval **Approval** PROCEDURE CHANGE DATE STEP By Qtv Date Chief Eng / QC Inspector Prod Mar Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval STEP** DATE Sign & Initial **Action Description** QC Inspector Section A Section C Chief Eng Chief Eng Date Chief Eng

DART AEROSPACE LTD	Work Order:	01639
Description: Bracket	Part Number:	D3542-1
Inspection Dwg: D3542 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First A	rticle	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø2.010	+0.005/-0.000	2.014	~		Vern	GA-01
Ø2.50	+0.012/-0.001	2.500	/		11	11
3.75	+/-0.030	3.749	/		11	11
2.50	+/-0.010	2.498	)		11	11
1.00	+/-0.010	1.000	/		11	11
0.06 x 45°	+/-0.030 x 0.5°	0.069x45°	~		11	cl
Ø0.266	+0.006/-0.001	00.269	~		11	11
1.00	+/-0.030	0.998	~		11	(1
0.50	+/-0.030	0.499	/		11	] (
0.500	+/-0.010	0.499	>		11	11

Measured by:	B.A	Audited by:	and	Prototype Approval:	N/A
Date:	11/04/06	Date:	11/04/06	Date:	N/A

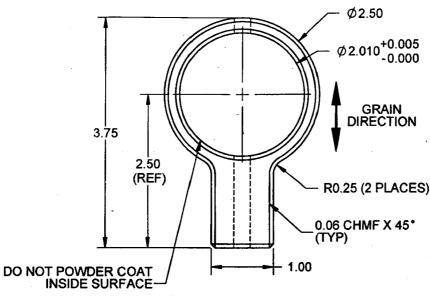
Rev	Date	Change	Revised by	Approved
Α	07.06.13	New Issue	KJ/JLM 🛠	E

W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		PAR #:	Fault Cat	NCR: Yes No DQA: Date:						
		esolution:	tion: Disposition:			: N/C Cld	Date:			
NCR:			WORK ORI	DER NON-CONFO	RMANC	E (NCR	)			
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verifi	Verification	Approval	Approval
DATE			Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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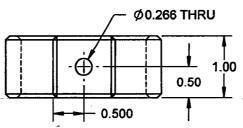
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ĺ	CHECK	(ED	APPROVED	DRAWING NO.	REV. A				
İ		B	-6	D3542	SHEET 1 OF 1				
	DATE			TITLE	SCALE				
	06.11.27			BRACKET	2:3				
	REV		DATE	DESCRIP	TION				
	Α		06.11.27	NEW ISSUE					



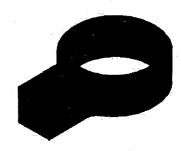


SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 67639

pl 103.29



**D3542-1 BRACKET** 



**NOTES** 

1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160

(REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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W/O:		WORK ORDER CHANGES									
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		PAR #:	_ Fault Category	y:	NC	R: Yes	No <b>DQ</b>	A:	Date:		
		esolution:	ution: Disposition:		QA: N/C Closed:				Date:		
NCR:		· . W	ORK ORDER	NON-CONFO	RMANC	E (NCF	R)				
		Description of NC	Corrective Action		Section B	Υ	Verific	Verification	Approval	Approvai	
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	ion 	Sign 8 Date	Secti		Chief Eng.	QC Inspector	
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NOTE: Date & initial all entries

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